

Work Order ID 86650

86650

Page 1

July-06-12 11:12:08 AM

Item ID: D3453-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Clevis
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: 12-07-10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3453	Rev B

100 0.00

100 6 ϕ

Doosan Memo 0.00

Doosan Lathe 1-Turn as per Folio FA577

Rev: N/A
 Dwg D3453 Rev: B
 2- Deburr as per dwg D3453

150 QC2- Inspect parts off machine FAI/FAIB 0.00

150 6 ϕ

QC Memo 0.00

Quality Control

160 QC8- Inspect parts - second check 0.00

160 6 ϕ

QC Memo 0.00

Quality Control

DAS
25
89 12-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86650

86650

Page 2

July-06-12 11:12:08 AM

Item ID: D3453-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clevis

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/27/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: W/A

0.00

170

Packaging

Memo

0.00

Packaging

6 12-12-10

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/12/10

ME
12-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-06-12 11:12:08 AM

Page 1

Work Order ID: 86650

Parent Item: D3453-1

Parent Item Name: Clevis

Start Date: 7/06/12

Required Date: 7/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	15.7400	0.288	1.728			
304 round bar 1.250													

Location	Loc Qty	Loc Code
MAT029	15.74	
105872	11.73	
108156	1.68	
111018	2.33	

2 RT SA 12/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86650
Description: Clevis		Part Number: D3453-1
Inspection Dwg: D3453	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

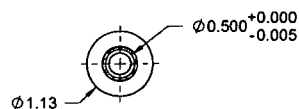
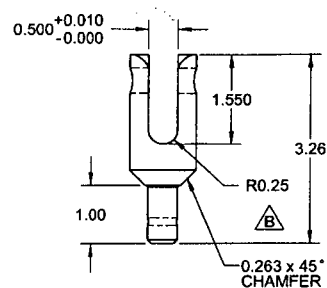
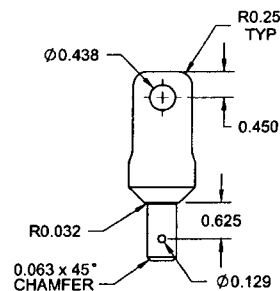
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	0.441	/		SS-4	Ver4
R0.25	+/-0.030	R.25	/			
0.450	+/-0.010	.4495	/			
0.625	+/-0.010	.625	/			
0.063 x 45°	+/-0.010 x 0.5°	0.063 x 45°	/			
Ø0.129	+0.005/-0.001	0.132	/			
3.26	+/-0.030	3.256	/			
1.00	+/-0.030	.998	/			
1.550	+/-0.010	1.550	/			
0.500	+0.010/-0.000	.505	/			
0.263 x 45°	+/-0.010 x 0.5°	0.263 x 45°	/			
R0.25	+/-0.010	R.25	/			
Ø1.13	+0.012/-0.001	Ø1.130	/			
Ø0.500	+0.000/-0.005	Ø.4975	/			

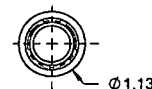
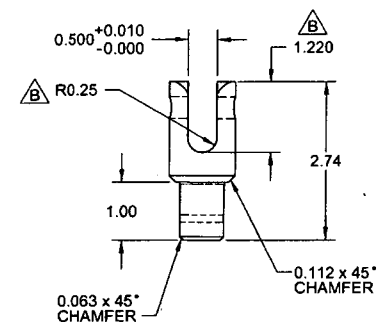
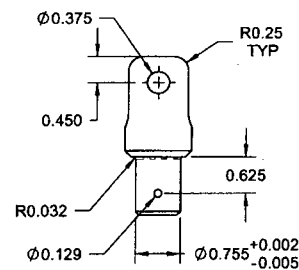
Measured by: D30 13	Audited by: D40 25	Prototype Approval:	N/A
Date: 12/11/21	Date: 12-11-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.30	New Issue	KJ/JLM	
B	07.01.17	Dimensions added	KJ/JLM	
C	08.10.09	Diameter symbol removed from 0.500 dimension	KJ/DD	
D	09.11.04	Dimensions updated per Dwg Rev B	KJ	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 86650 PD12-07-6



D3453-1 CLEVIS



D3453-3 CLEVIS

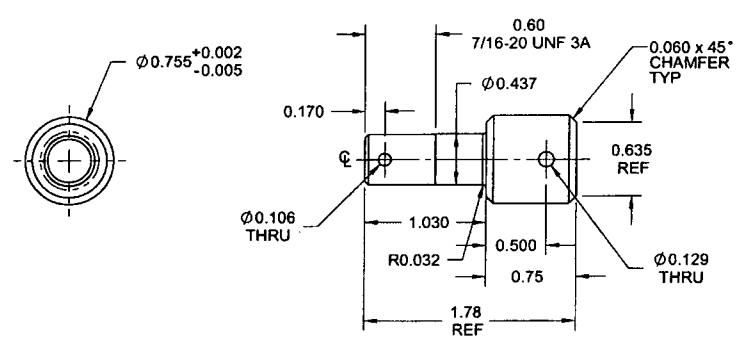
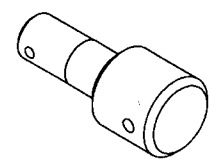
RELEASED
 07/08/25/MPD

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
 D3453-3 = 0.41 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN C5-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018	RF	09.05.21
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3453	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLEVIS	NTS
DATE	09.05.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

86650



D3453-5 PLUG

RELEASED
09/05/21

- D3453-5 NOTES:**
- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3453	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLEVIS	NTS
DATE	09.05.21	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	